

Date: Wednesday, 21/11/2007 3:18:26 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HELI-ACCESS STEP LH (FOLDING)
<b>Job Number</b>	: 35956		
<b>Estimate Number</b>	: 12567		
<b>P.O. Number</b>	: <i>N/A</i>	<b>Part Number</b>	: D412630033
<b>This Issue</b>	: 21/11/2007	<b>Drawing Number</b>	: IIN D412-630
<b>Prsht Rev.</b>	: <i>NC</i>	<b>Project Number</b>	: <i>N/A</i>
<b>First Issue</b>	: <i>N/A</i>	<b>Drawing Revision</b>	: <i>L</i>
<b>Previous Run</b>	: 35797	<b>Material</b>	: <i>N/A</i>
<b>Written By</b>	: <i>[Signature]</i>	<b>Due Date</b>	: 23/11/2007
<b>Checked &amp; Approved By</b>	: <i>[Signature]</i>	<b>Qty:</b>	1
<b>Comment</b>	Est. Rev: A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by: DD		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-033 CHG003

*Handwritten: 21/11/23*

2.0

D2012107

Clevis

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

*Handwritten: B33585*

*Handwritten: SP*

3.0

D2803041

Bracket Assembly

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-041	Bracket Assembly LH

Batch

*Handwritten: B32772*

*Handwritten: X SG*

4.0

D2804041

Bracket Assembly

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-041	Bracket Assembly LH

Batch

*Handwritten: B329404*

*Handwritten: 7/11/21 SP*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 21/11/2007 3:18:26 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35956

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

GAS SPRING ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Support Prop

Batch: B35961

SP

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch: 1729396

SP

7.0

D3562041

STEP ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-041	Step Weldment LH

Batch: B35262

SP

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch: 1733578

SP

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch: 17101189

7/11/21 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35956

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

M102736

SP

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M102728

SP

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

SP

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M103164

SP

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M105192

M11/2150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35956

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M104871

SP

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M103192

SP

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101391

7/11/21 (X) SP

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M104929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON

BATCH: M17045

MF 02-11-23 (1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/14/23 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 21/11/2007 3:18:26 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35956

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

1333590

SC

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

1429847

SC

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

132115

SC

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

1329496

SC

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

7/11/21 SC

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

Date: Wednesday, 21/11/2007 3:18:26 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35956

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M101189

SP

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M103915

SP

28.0

AN4C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C7A

Eyebolt

M101711

SP

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M101291

SP

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M105516  
M104715 7/11/2 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/11/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 21/11/2007 3:18:26 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 35956

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

4105792, 54

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

4105793, 50

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

4105430, 7/6/21 50 (1x)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

Rev A 7/14/23 50 (1x) B

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



7/11/23

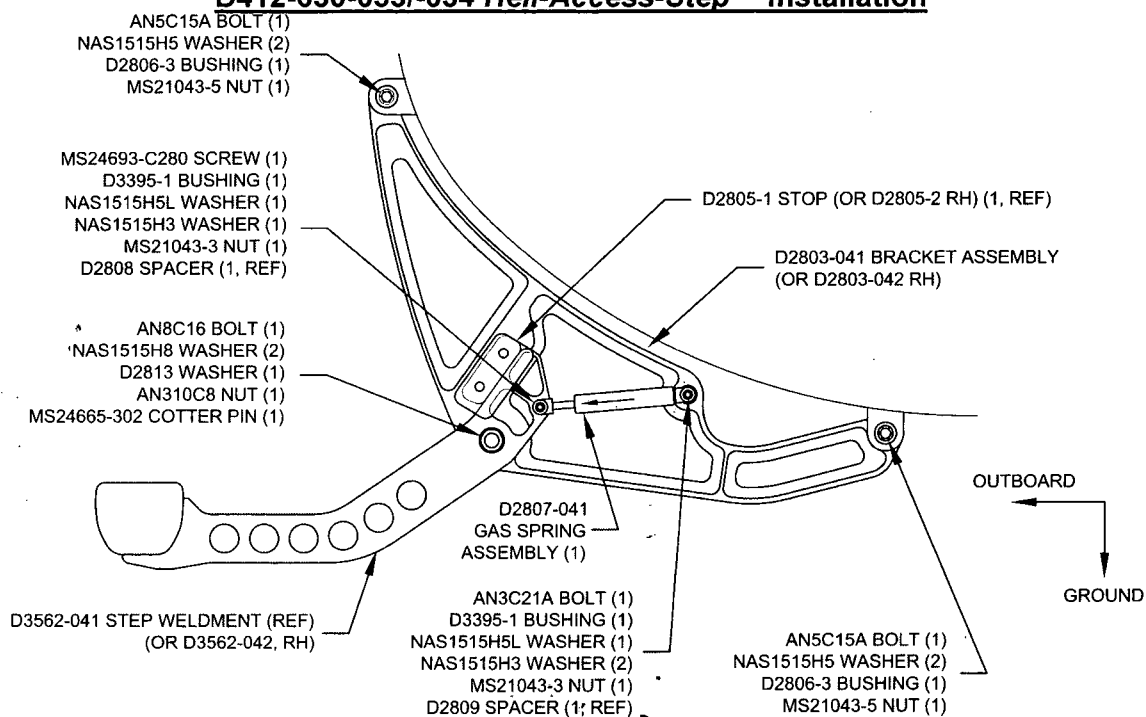
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

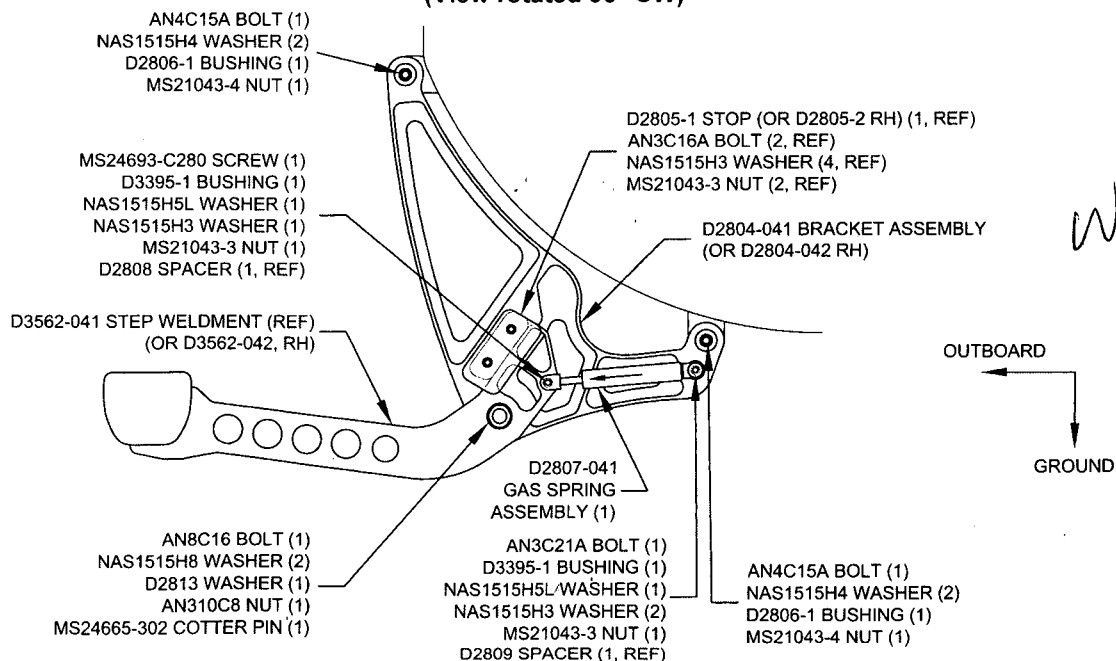
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

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Revision: L  
Date: 07.09.30

Date: Wednesday, 11/21/2007 3:18:02 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS STEP LH (FOLDING)
Job Number : 35956	
Estimate Number : 12567	
P.O. Number :	Part Number : D412630033
This Issue : 11/21/2007 S.O. No. :	Drawing Number : IIN D412-630
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : L
Previous Run : 35797	Material :
Written By : <u>                    </u>	Due Date : 11/23/2007 Qty: 1 Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-033 CHG003

07.11.21 *[Signature]*

2.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Pick:

**REFERENCE ONLY**

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	

3.0	D2803041	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-041	Bracket Assembly LH	

4.0	D2804041	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-041	Bracket Assembly LH	

Job Completion

